

5/46

DART AEROSPACE LTD	Work Order:	24701
Description: Bushing RF 04.11.29	Part Number:	D3155-3
Drawing: D3155 Rev. A1 C RF 03.02.24	Qty:	20

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	RF	05.10.26	20
2	STORES	Pick: Qty Part number Description Batch 1 SS-812-20 Symmco bushing 1 Symmco bushing makes 2 parts.			
3	CNC-CELL	Machine to length Folio FA243			
4	CNC-CELL	Deburr bushing inside and out.			
5	QC	Inspect Level 5			
6	STORES	Identify and stock.			
7	EXPEDITING	Close W/O Inspect level 21 Cost / part			

Rev	Date	Change	Revised By	Approved
A	02.05.27	New Issue	NG 02-05-30	

RELEASED

02/05/28

UNDER REVIEW

03.05.03 RF

STOCK MATERIAL UNDER REVIEW MADE FROM
SOLID ROUND BAR

Manufactured the Same Way!
JMM 05.10.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

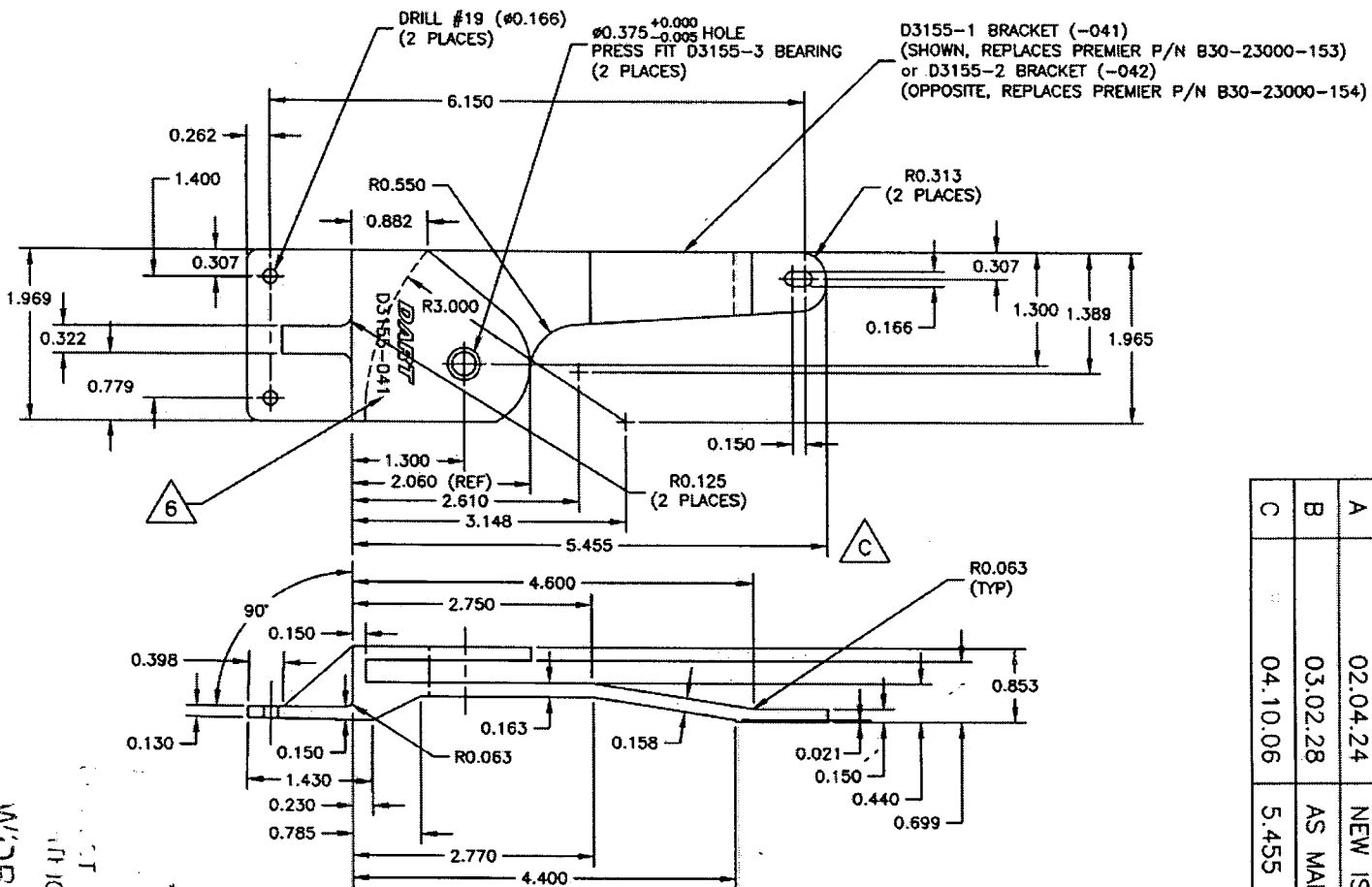
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

GA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D3155	SHEET 1 OF 2
04.10.06		TITLE BRACKET ASSEMBLY	
A	02.04.24	NEW ISSUE	
B	03.02.28	AS MANUFACTURED	
C	04.10.06	5.455 WAS 5.550	
		SCALE 1:2	



D3155-041 BRACKET ASSEMBLY

(SHOWN, REPLACES PREMIER P/N B30-23000-11)

D3155-042 BRACKET ASSEMBLY

(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

D3155-1/-2 BRACKET

- 1) MATERIAL: 6061-T6/-T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN

04.11.23

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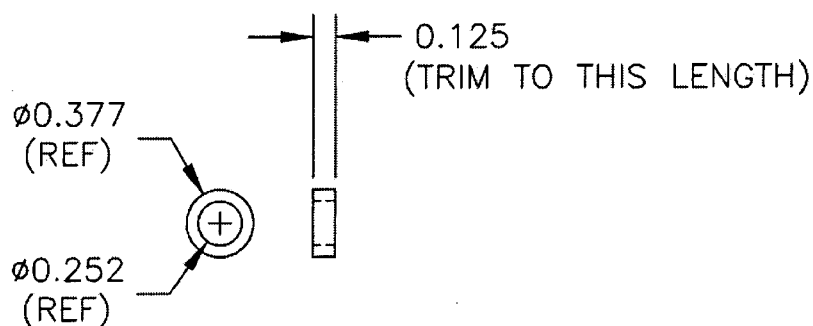
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WORK COPY
NO. 24701



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3155	REV. C SHEET 2 OF 2
DATE 04.10.06		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED
04.11.23 *[Signature]*



D3155-3 BUSHING

- 1) MAKE FROM P/N SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)
POSSIBLE SUPPLIER: SYMMCO
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

STAMP COPY
RETURN TO
ENGINEERING

CONTROL

NO. 24701

WORK O

NO. 24701

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 26, 2005
03:12 pm

Work Order No : 0024701
Project Name : D3155-3
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D3155-3
Description : Bushing
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 10-26-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00